

Date: Friday, 17/08/2007 11:20:41 AM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: NUT PLATE ASSEMBLY
Job Number	: 34077		
Estimate Number	: 11054		
P.O. Number	: <i>N/A</i>	Part Number	: D2873045
This Issue	: 17/08/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D2873 REVA
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 33692	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 05/09/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	80 Um: Each
Comment	: Est A05.09.13 New issue KJ/JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0375X01000	6061T6 BAR
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Comment: Qty.: 0.2363 f(s)/Unit Total : 18.9000 f(s)  
 6061T6 BAR  
 Material: 6061-T6 Bar (QQ-A-200/8 or QQ-A-225/8)  
 (M6061T6B0.375x01.000)  
 Identify for D2873-5  
 Batch: *1105445*

*[Signature]* 07.09.28 (80)

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW  
 Cut blanks: 1.000" x 0.375" x 2.700" long

*[Signature]* 07.09.28 (80)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1  
 Machine as per Folio FA and Dwg D2873  
 Identify as D2873-5 Dwg Rev *A* Folio Rev *A1*

(80)

*86* 07.10.01 (80)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*86* 07.10.01 (80)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 17/08/2007 11:20:41 AM  
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Drawing Name: NUT PLATE ASSEMBLY

Job Number: 34077

Part Number: D2873045

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

*mk 07/10/01*

*(80)*

6.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

2- C'sink as per Dwg D2873

*SAD 07-10-03*

*control 80*

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*SA 07/10/04*

*(80)*

8.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*SAD 07-10-07*

*(80)*

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION

*ST 07-10-07*

*(80)*

10.0 MS20426AD46 Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total: 320.0000 Each(s)

Rivet

Pick;

Qty	Part Number	Description	Batch
4	MS20426AD4-6	Rivet	M100151 (140)

*SAD 07/10/20*

*M103395 (80)*

11.0 MS21075L5 Nut Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 160.0000 Each(s)

Nut Plate

Pick;

Qty	Part Number	Description	Batch
2	MS21075L5	Nut Plate	M18136

*SAD 07/10/20*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: PD Date: 07/11/23  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 17/08/2007 11:20:41 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: NUT PLATE ASSEMBLY

Job Number: 34077

Part Number: D2873045

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D2873

2-Identify as D2873-045

3AD 17-10-20 80

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

17/10/22 (+80)

Controlled  
records

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Tube assembly

17/10/27 (C80)

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

17/10/23 (80)

Job Completion



17/10/23

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

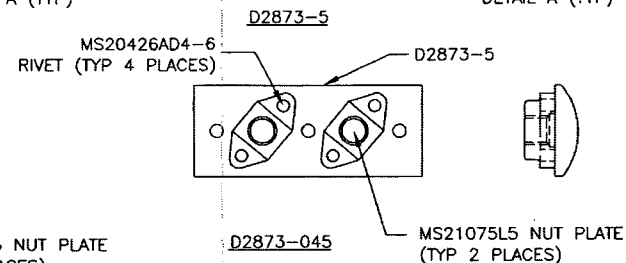
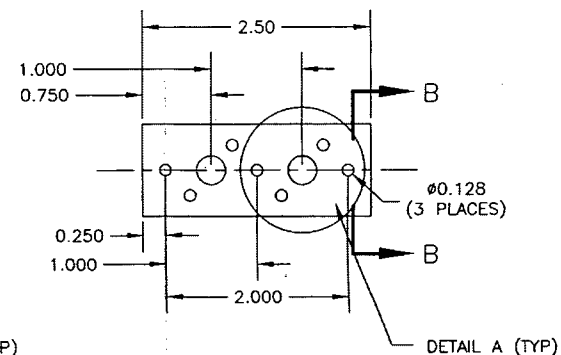
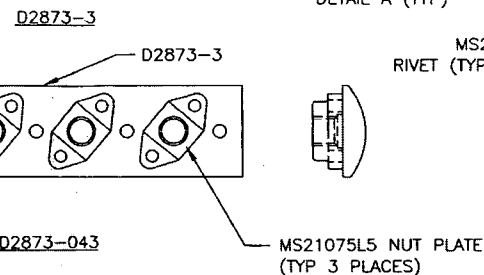
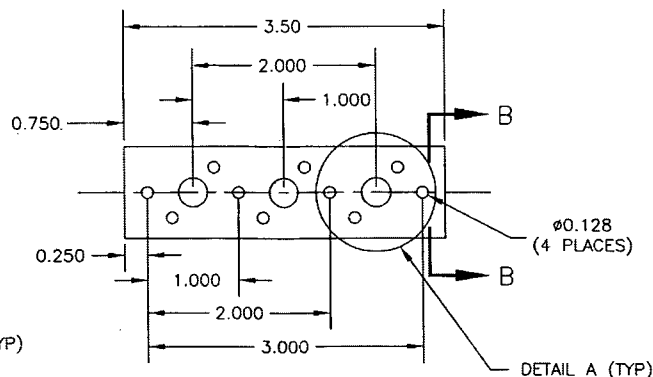
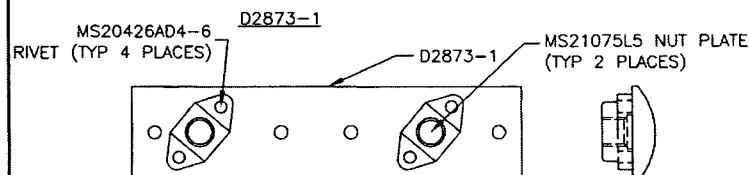
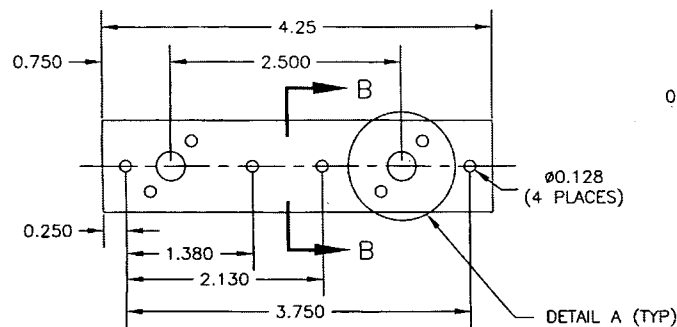
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries





#### D2873-1/-3/-5 RADIUS BLOCK

- 1) MATERIAL: 5052-H32/H34 BAR (QQ-A-225/7) (REF. DART SPEC M5052H32B1.000X0.250) OR 6061-T6 BAR (QQ-A-225/8 OR QQ-A-200/8) (REF. DART SPEC M6061T6B1.000X0.250)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) Ø0.128 PILOT + C'BORE CURVED SIDE Ø0.230X0.125 DEEP + C'SINK CURVED SIDE Ø0.225 x 100'

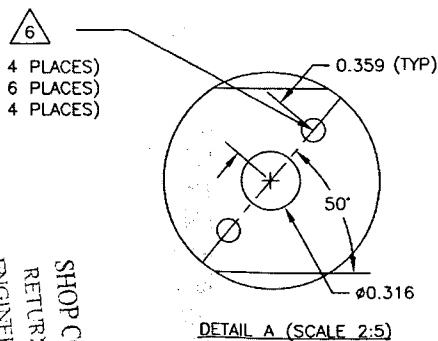
#### D2873-041/-043/-045 NUT PLATE ASSEMBLY

- 1) INSTALL MS21075L5 NUT PLATE IN ORIENTATION SHOWN USING MS20426AD4-6 RIVETS

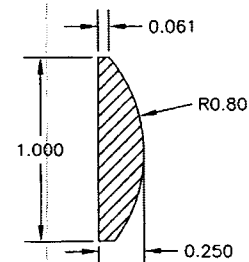
#### D2873-041/-043/-045 NUT PLATE ASSEMBLY PARTS LIST

-041	-043	-045	PART NUMBER	DESCRIPTION
X			D2873-041	NUT PLATE ASSEMBLY
	X		D2873-043	NUT PLATE ASSEMBLY
		X	D2873-045	NUT PLATE ASSEMBLY
1			D2873-1	RADIUS BLOCK
	1		D2873-3	RADIUS BLOCK
		1	D2873-5	RADIUS BLOCK
4	6	4	MS20426AD4-6	RIVET
2	3	2	MS21075L5	NUT PLATE

(-041 4 PLACES)  
(-043 6 PLACES)  
(-045 4 PLACES)



DETAIL A (SCALE 2:5)



SECTION B-B (SCALE 2:5)

RELEASED  
05-07-26

WORK ORDER  
26077  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
ENGINEERING  
RETURN TO  
SHOP COPY

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A	05.07.26	NEW ISSUE
DESIGN PH	DRAWN BY PH	<b>DART</b> DART AEROSPACE LTD WINDYBURY, ONTARIO, CANADA
CHECKED DS	APPROVED DS	DRAWING NO. D2873
DATE 05.07.26		TITLE RADIUS BLOCK
		REV. A SHEET 1 OF 1 SCALE 4:5